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GROUP 1700IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Serial No. 10/022,322
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Group 1762

METHOD OF PRODUCING THERMALLY
SPRAYED METALLIC COATING

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AMENDMENT IN RESPONSE TO PAPER NO. 4

Commissioner for Patents
Washington DC 20231

This is applicants' response to the Office Action mailed December 9, 2002 in which all of claims 1-11 filed in the case were rejected. Applicants respectfully request reconsideration and allowance of the claims now in the case in view of the following amendments and remarks.

IN THE CLAIMS:

Amend claims 1-3 and 5 as follows:

1. (Amended) A method of thermally spray coating a cylinder wall of a metal engine block, said method comprising:
- providing a high velocity oxygen fuel (HVOF) device;
 - advancing a feed wire of ferrous-based material into the HVOF device to locate a tip end of the wire in a high temperature zone of the HVOF device;
 - supplying a high velocity jet flow of gaseous fuel to the high temperature zone of the HVOF device;

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supplying a high velocity jet flow of oxygen to the high temperature zone of the HVOF device and combusting the oxygen and fuel to generate sufficient heat in the high temperature zone to melt the tip end of the feed wire in the high temperature zone and spraying the molten feed wire material onto the cylinder wall surface of the engine block forming a coating thereon; and

controlling the flow of the oxygen relative to the flow of the gaseous fuel to provide an oversupply of oxygen in excess of the oxygen required for stoichiometric combustion of the gaseous fuel, and reacting the excess oxygen with an associated fraction of the wire feed material in the high temperature zone to combust the associated fraction of the wire feed material as a source of solid fuel to provide a supplemental source of heat to the high temperature zone of the HVOF device, and wherein the amount of oversupply of oxygen is sufficient to increase the deposition rate of the molten metal on the cylinder wall by more than twofold than that deposited when oxygen is supplied at that required for stoichiometric combustion of the gaseous fuel.

2. (Amended) The method of claim 1 wherein the oxygen is oversupplied in an amount about at least twice that needed for stoichiometric combustion with the fuel.

4/3. (Amended) The method of claim 1 wherein the oversupply of oxygen is in an amount about twice that needed for stoichiometric combustion with the fuel.

7/5. (Amended) A method of thermally spray coating a cylinder wall of a metal engine block, said method comprising:

providing a high velocity oxygen fuel (HVOF) device;

advancing a feed wire of ferrous-based material into the HVOF device to locate a tip end of the wire in a high temperature zone of the HVOF device;

supplying a high velocity jet flow of gaseous fuel to the high temperature zone of the HVOF device;

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supplying a high velocity jet flow of oxygen to the high temperature zone of the HVOF device and combusting the oxygen and fuel to generate sufficient heat in the high temperature zone to melt the tip end of the feed wire in the high temperature zone and spraying the molten feed wire material onto the cylinder wall surface of the engine block forming a ferrous-based coating thereon; and

controlling the flow of the oxygen relative to the flow of the gaseous fuel to provide an oversupply of oxygen in excess of the oxygen required for stoichiometric combustion of the gaseous fuel, and reacting the excess oxygen with an associated fraction of the wire feed material in the high temperature zone to combust the associated fraction of the wire feed material as a source of solid fuel to provide a supplemental source of heat to the high temperature zone of the HVOF device; and wherein the ferrous-based coating includes additions of aluminum, and wherein the amount of oversupply of oxygen is sufficient to increase the deposition rate of the molten metal on the cylinder wall by more than twofold than that deposited when oxygen is supplied at that required for stoichiometric combustion of the gaseous fuel.

Add claims 12-15 as follows:

512. The method of claim 1 wherein the metal engine block comprises at least one of aluminum, magnesium and alloys thereof.

1413. The method of claim ⁷5 wherein the metal engine block comprises at least one of aluminum, magnesium and alloys thereof.

614. The method of claim 1 wherein the gaseous fuel comprises at least one of methane and propane.

1515. The method of claim ⁷5 wherein the gaseous fuel comprises at least one of methane and propane.